

*Work Order ID 84339

84339

ASAP

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Wednesday, May 09, 2012 4:44:08 PM

Item ID: D3307-3

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Gasket

Start Date: 5/9/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/18/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MVF

Date: 12-05-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3307

Rev A

Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3307 Dwg Rev: A Prog Rev: 1A 2-
Deburr if necessary

10 0 JM
(2-5-13)

*035 MOURAS

Blk Gasket
(77224)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

10 0 JM
12-5-13

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

10 0 12.05 14
(10)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84339

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Wednesday, May 09, 2012 4:44:08 PM

Item ID: D3307-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Gasket

Stop *NS2*

Start Date: 5/9/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 5/18/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>233A</u>	0.00							
130									
Packaging	Memo	0.00				102			12/5/14
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/5/15
MK
12-05-15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84339

Parent Item: D3307-3

Parent Item Name: Gasket

Start Date: 5/9/2012

Required Date: 5/18/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: A04.09.24New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3245 Gasket		Manufactured	No			100	Each	45.0000	0.257	2.7052632			

Location

Loc Qty

Loc Code

MAT052

45

77224

45

77224.

Jm
12-5-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 84339
Description: Gasket		Part Number: D33073
Inspection Dwg: D33073 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.364	±0.010	0.364	✓		✓	HB-02
0.688	±0.010	0.688	✓		✓	HB-02
3.563	±0.010	3.563	✓		✓	HB-02
5.136	±0.010	5.136	✓		✓	HB-02
5.988	±0.010	5.988	✓		✓	HB-02
0.75	±0.030	0.75	✓		✓	HB-02
3.338	±0.010	3.338	✓		✓	HB-02
0.388	±0.010	0.388	✓		✓	HB-02
5.500	±0.010	5.500	✓		✓	HB-02
4.813	±0.010	4.813	✓		✓	HB-02
1.938	±0.010	1.938	✓		✓	HB-02
R0.50	±0.030	0.50	✓		RG	
0.688	±0.010	0.688	✓		✓	HB-02
0.188	±0.005	0.188	✓		✓	HB-02
6.288	±0.030	6.288	✓		✓	HB-02
6.676	±0.010	6.676	✓		✓	HB-02
R0.75	±0.030	0.75	✓		RG	

Measured by: JM	Audited by:	Prototype Approval:	N/A
Date: 12-5-13	Date: 12-05-14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	